

Work Order ID 85971

85971

Page 1

June-19-12 11:58:50 AM

Item ID: D2364

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2364	Rev F

100	FLOW WATER JET	0.00
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

10 0 Jm 12-6-23

2024.06.23

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-23

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Memo

0.00

Quality Control

10 0 M 120624

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85971

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 19/06/2012 **Start Qty:** 10.00

10

Customer:

Required Date: 03/07/2012 **Req'd Qty:** 10.00

10

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1- counter sink holes as per dwg D23642- deburr if necessary

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 19/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location: **8-224** 0.00

180

Packaging

Packaging

Memo

0.00

10x ϕ **mf**
12/07/03

10 ϕ **BL 12-7-3.**

10x ϕ **80**
12-7-3.

W121279

8-15

3200F

8-45

W/O:		WORK ORDER CHANGES					
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Work Order ID 85971***85971***

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Item ID: D2364

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

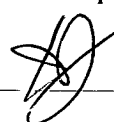
190

QC

Memo

0.00

Quality Control

12/7/4 MF
12-07-03

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NOTE: Date & initial all entries

Picklist Print

June-19-12 11:58:53 AM

Page 1

Work Order ID: 85971

85971

Parent Item: D2364

D2364

Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	268.9700	0.6469	6.809474			

M2024T3S 063

2024-T3 .063 sheet

**

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT022

268.97

119916

73.27

121197

195.7

121197

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DART AEROSPACE LTD		Work Order:	85971
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.631"	✓		V	mmoi
Ø0.171	+0.005/-0.000	0.172"	✓		V	"
0.354	+/-0.010	0.360"	✓		V	"
11.242	+/-0.010	11.246"	✓		V	Produced
3.031	+/-0.010	3.036"	✓		V	mmoi
1.903	+/-0.010	1.904"	✓		V	"
1.128	+/-0.010	1.129"	✓		V	"
0.354	+/-0.010	0.358"	✓		V	"
1.340	+/-0.005	1.341"	✓		V	"
2.326	+/-0.010	2.327"	✓		V	"
3.312	+/-0.010	3.310"	✓		V	"
4.298	+/-0.010	4.296"	✓		V	"
5.284	+/-0.010	5.283"	✓		V	"
6.151	+/-0.010	6.151"	✓		V	"
6.270	+/-0.010	6.269"	✓		V	"
0.354	+/-0.010	0.360"	✓		V	"
3.031	+/-0.010	3.036"	✓		V	"
Ø0.656	+0.005/-0.000	0.656"	✓		V	"
5.003	+/-0.010	5.005"	✓		V	"
4.605	+/-0.010	4.607"	✓		V	"
1.776	+/-0.010	1.782"	✓		V	"
0.980	+/-0.010	0.986"	✓		V	"
4.487	+/-0.010	4.484"	✓		V	"
7.192	+/-0.010	7.199"	✓		V	"
7.567	+/-0.010	7.567"	✓		V	"
7.942	+/-0.010	7.940"	✓		V	"
Ø0.191	+0.005/-0.000	0.191"	✓		V	"
Ø0.197	+0.005/-0.000	0.197"	✓		V	"
11.145	+/-0.010	11.151"	✓		V	Produced
12.181	+/-0.010	12.181"	✓		MT	HBOI
11.378	+/-0.010	11.384"	✓		V	Produced
11.776	+/-0.010	11.777"	✓		V	Produced
12.173	+/-0.010	12.173"	✓		MT	Produced HBOI
4.690	+/-0.010	4.696"	✓		MT	HBOI
0.250	+0.005/-0.000	0.250"	✓		V	mmoi
3.141	+/-0.010	3.149"	✓		V	mmoi
0.171	+0.005/-0.000	0.171"	✓		V	mmoi

Measured by:	Sm	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	12-6-23	Date:	12-06-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	[Signature]

Dart Aerospace Ltd

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